

Date: Thursday, 11/16/2006 4:25:06 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT CROSSTUBE		
Job Number	: 29479			Part Number	: D2890		
Estimate Number	: 10377			Drawing Number	: D2890 REV B		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 11/16/2006	S.O. No.	: N/A	Drawing Revision	: B		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: N/A			Due Date	: 12/10/2006		
Previous Run	: 29478			Qty:	1	Um:	Each
Written By	: <i>PH Abell</i>						
Checked & Approved By	: <i>PH Abell</i>						
Comment	: Est. D 05.03.21 Removed Bending procedures KJ/JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6008180	Crosstube extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part # Description Batch 1 D6008-180 Crosstube extrusion <i>B22534 DP 6-11-21</i>		
2.0	BENDING	BENDING MACHINE
Comment: BENDING MACHINE 1-Bend D2890 as per Dwg D2890 and Folio FT002 <i>DP 6-11-28</i>		
3.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK <i>Job 12-06 0</i>		
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1-Deburr and Polish <i>N/A DP 7-1-23</i>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>N/A DP 7-1-23</i>		

*case# 29065*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/13  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/16/2006 4:25:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 29479

Part Number: D2890

Job Number:

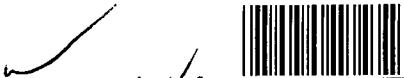


Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M/B*

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*PPP B 29065 2/15/13*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*1 207/01/31*

Job Completion



*W 07/01/31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

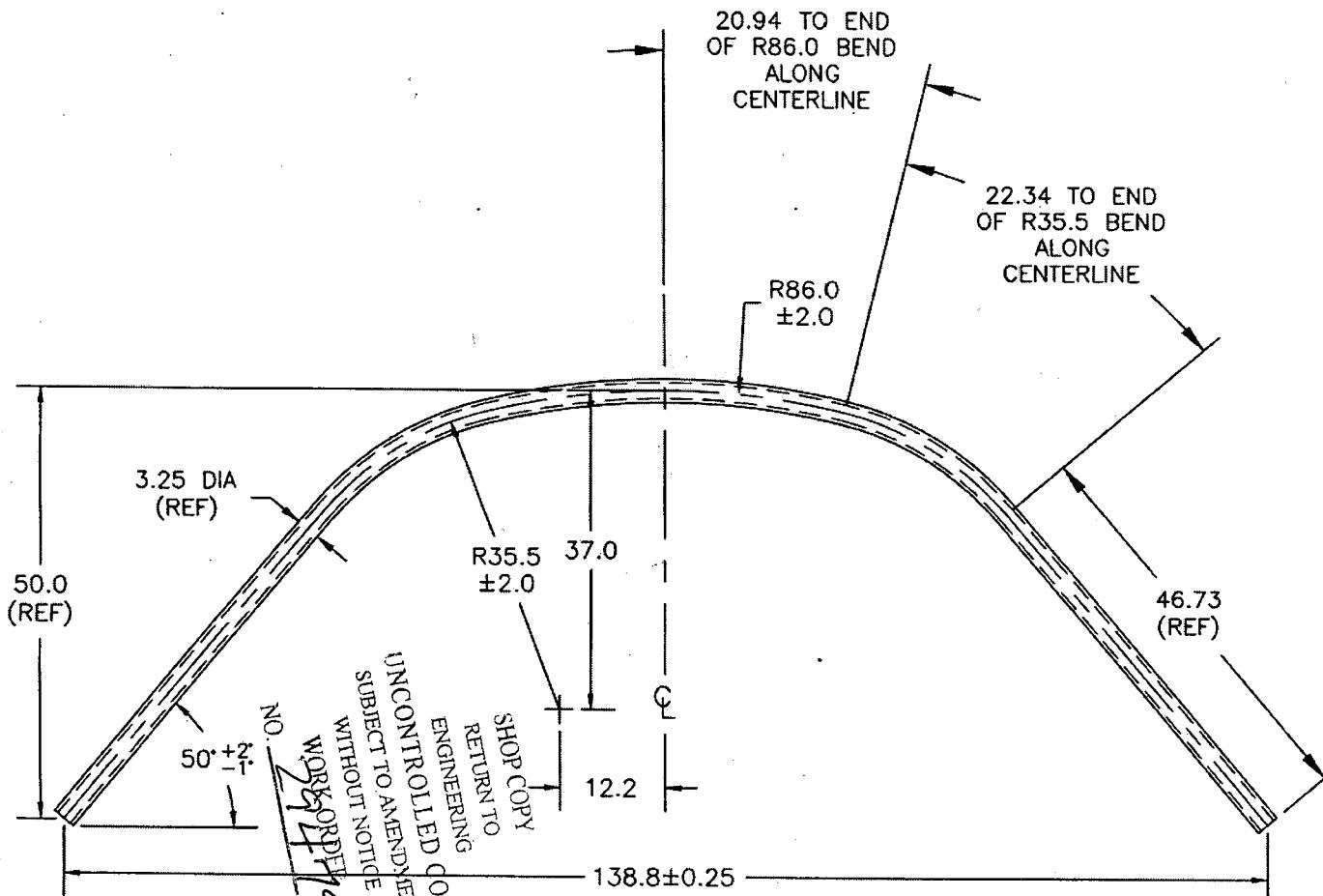
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**DRAFTS  
OR COPY  
ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD
	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2890
DATE	TITLE	REV. B
02.10.18	AFT CROSSTUBE	SHEET 1 OF 1
		SCALE
		1:20

**RELEASED**  
02.10.28

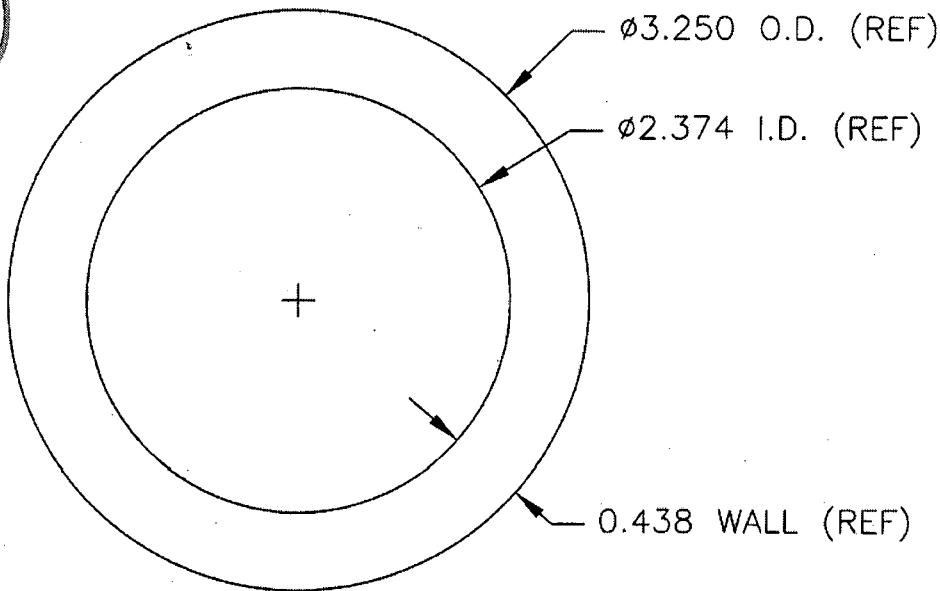


1 COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D6008
DATE		REV. A SHEET 1 OF 1
00.11.17		SCALE 1:1
A	00.11.17	NEW ISSUE

## SPECIFICATION CONTROL DRAWING

RELEASED  
00.11.24



### NOTES

1) D6008-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES  
EG. 180" LONG TUBE: D6008-180

2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.  
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi  
MINIMUM YIELD TENSILE STRENGTH = 66 ksi

3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:  
O.D.:  $\pm 0.008$  MEAN ( $\pm 0.016$  INCLUDING OVALITY)  
WALL:  $\pm 0.020$  MEAN ( $\pm 0.044$  INCLUDING ECCENTRICITY)  
LENGTH: XXX  $+0.125/-0.000$   
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

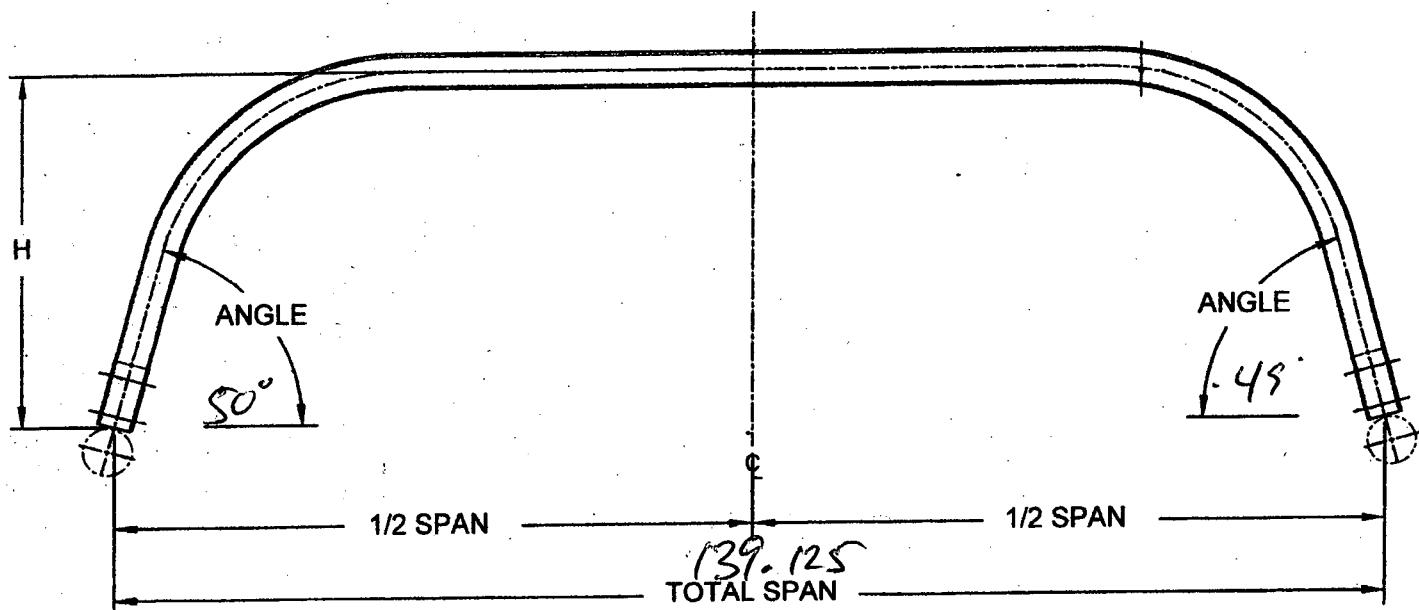
5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

SHOP COPY  
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INCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29479

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# Crosstube Bend Dimension Sheet



See WO 205-596-103  
B29065

PART NUMBER: 2890

BATCH NUMBER: 29479

DRAWING: 2890 REVISION: B

H: N/A

1/2 SPAN: N/A

TOTAL SPAN:  $138.8 \pm .25$

ANGLE:  $50^{\circ} \pm 1$

QC 15: J

DATE: 06-12-06

QTY: 1

